LH

Work Order ID 77974 *77974*

December-23-11 10:34:25 AM

Item ID:	D206-642-151	**Accept**	*N900040100*
Revision ID:		**Setup Start**	*NS1*
Item Name:	Replacement Skidtube	**Stop**	*NS2*
Start Date:	22/12/2011	**Start Qty:** 1.00	*1*
Required Date:	01/02/2012	**Req'd Qty:** 1.00	*1*
Reference:			

Cust Item ID:
Customer:

Approvals: **Process Plan:** M.L.J **Date:** 11/12/23 **Tooling:** ______ **Date:** ______

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Run Start *NR1* **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

Draw Nbr	Revision Nbr
D3804	A
IIN-D206-642	O

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours		
100 *100* DC	DOCUMENT CONTROL	0.00 0.00	N/A	
Document Control	**Memo** Photocopy bluefile & type labels per PPP D206-642-151		CHG001	

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** ________

Resolution: ____________ **Disposition:** ____________ **QA: N/C Closed:** ________ **Date:** ________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 77974 *77974*

December-23-11 10:34:25 AM

Item ID: D206-642-151 **Accept** *N900040100* **Setup** **Start** *NS1*

Revision ID:

Item Name: Replacement Skidtube **Stop** *NS2*

Start Date: 22/12/2011 **Start Qty:** 1.00 *1* **Cust Item ID:**

Required Date: 01/02/2012 **Req'd Qty:** 1.00 *1* **Customer:**

Reference:

Run **Start** *NR1*

Approvals: **Process Plan:** ________ **Date:**______ **Tooling:** ________ **Date:**______

QC: ________ **Date:**______ **SPC (Y/N):** ________ **Date:**______ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 *110* Skidtubes	Skidtubes	0.00							
Skidtubes	Memo	0.00							

1-Deburr Fwd edge of tube

2- Remove ridge on inside of Fwd edge of tube as per Dwg D3804 } SAD 12-01-10

3-Weld Fwd Cap as per Dwg D3804. Use aluminum rod. Grind D2647 to fit as required.
Pick:
Qty Part Number Description Batch m119712
A/R Aluminum Rod m119785 BE 12-01-10

4-Grind weld flush to cap on top surface only.

5-Cut Aft end as per dwg D3804 from front of tube and Deburr

6-Remove inner indexing ridge on Aft end of skidtube as per Dwg D3804

7-Open holes for Aft end cap as per Dwg D3804 with #30 Drill Bit using DT8025.

8-Drill pilot holes using Dt8166 & DT8169D & DT9771.

9-Locate DT8732 from inner Aft saddle hole & 3rd crossbolt hole. Insert D3286-1 doubler using DT8732 & D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732 & doubler leaving DT8732 for added support.

10- Drill D3286-1 doubler rivet holes in tube using # 30 drill, spot drilling doubler at the same time.

} SAD 12-01-10

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W/O:	WORK ORDER CHANGES						
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Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

Resolution: ____________________ **Disposition:** ____________________ **QA: N/C Closed:** __________ **Date:** _________

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Work Order ID 77974 *77974*

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Item ID: D206-642-151 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID:

Item Name: Replacement Skidtube **Stop** *NS2*

Start Date: 22/12/2011 **Start Qty:** 1.00 *1* **Cust Item ID:**

Required Date: 01/02/2012 **Req'd Qty:** 1.00 *1* **Customer:**

Reference:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
	11-Working from the center out, drill # 30 holes into D3286-1 doubler. Cleco each hole as it is being drilled. Verify angle of holes to accommodate rivet heads. 12-Remove 3/16" cleco's only and open GHW holes to Ø0.500" as per Dwg D3804 13-Remove D3286-1 doubers, identify orientation, deburr, then attach them to the workorder		SAD 12-01-10						
	14-Remove indexing edge using DT8741 as per Dwg D3804 15-C'sink GHW rivet holes as per Dwg D3804 16- Open Aft cap hole #6. ****no wearplate holes for this skidtube**** 17-Deburr tube and blow out chips from inside the tube				DL 12/01/11				
120 *120* QC Quality Control	QC6- Inspect dimensions to drawing	0.00	S 12/01/11						
	Memo	0.00							

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

Resolution: ____________________ **Disposition:** ____________________ **QA: N/C Closed:** __________ **Date:** _________

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID 77974

December-23-11 10:34:25 AM

77974

Item ID: D206-642-151 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Replacement Skidtube

Start Date: 22/12/2011 **Start Qty:** 1.00 *1* **Cust Item ID:**

Required Date: 01/02/2012 **Req'd Qty:** 1.00 *1* **Customer:**

Reference:

Approvals: **Process Plan:** ________ **Date:** ________ **Tooling:** ________ **Date:** ________ **Run Start** *NR1*

QC: ________ **Date:** ________ **SPC (Y/N):** ________ **Date:** ________ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1	0.00				1	CF/		12-1-11
	Memo	0.00							
150 *150* QC Quality Control	QC3- Inspect Part Finish	0.00				1	SAD		12-01-11
	Memo	0.00							
160 *160* Skidtubes Skidtubes	Skidtubes	0.00							
	Memo 1-Open holes to finished size as per Dwg D3804, (without cutting fluid) 2-C'sink crossbolt spacer holes as per Dwg D3804(without cutting fluid) 3-Deburr and blow out all chips from inside the tube	0.00							

DC 1/30/11

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

Resolution: ____________________ **Disposition:** ____________________ **QA: N/C Closed:** __________ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 77974
December-23-11 10:34:25 AM

77974

Item ID: D206-642-151
Revision ID:
Item Name: Replacement Skidtube

Accept *N900040100*

Setup Start *NS1*
Stop *NS2*

Start Date: 22/12/2011 **Start Qty:** 1.00 *1*
Required Date: 01/02/2012 **Req'd Qty:** 1.00 *1*
Reference:

Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** ________ **Date:** ________ **Tooling:** ________ **Date:** ________
QC: ________ **Date:** ________ **SPC (Y/N):** ________ **Date:** ________

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 *170* QC Quality Control	QC6- Inspect dimensions to drawing	0.00				1	Ø	BE12-01-11	
	Memo	0.00							
180 *180* Skidtubes Skidtubes	Skidtubes	0.00							
	Memo	0.00							

1-Locate, install and rivet doublers as per Dwg D3804. Micro-shave rivets as required — DR 12/01/11

2-Bond D2654-1 web in place as per QSI 015. Ensure holes line up.Allow 12 Hrs. cure time before cutting
Start Date: 12/01/11 Time: 2:20
Finish Date: 12/01/12 Time: 8:30 — JB 12/01/11

Pick:
Qty Part NumberDescriptionBatch
A/RSikaflex-291 119508
Sikaflex expire date: 12/08/13

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W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

Resolution: ___________________ **Disposition:** ____________________ **QA: N/C Closed:** _________ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Item ID: D206-642-151 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID:

Item Name: Replacement Skidtube **Stop** *NS2*

Start Date: 22/12/2011 **Start Qty:** 1.00 *1* **Cust Item ID:**

Required Date: 01/02/2012 **Req'd Qty:** 1.00 *1* **Customer:**

Reference:

Run Start *NR1*

Approvals: **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190*	QC5- Inspect part completeness to step on W/O	0.00				1	0		BB 12-01-12
QC Quality Control	**Memo**	0.00							

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ PAR #: _______ Fault Category: _________________ NCR: Yes No DQA: _____ Date: _________

Resolution: ___________________ Disposition: ____________________ QA: N/C Closed: _________ Date: _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 77974

December-23-11 10:34:25 AM

77974

Item ID: D206-642-151

Revision ID:

Item Name: Replacement Skidtube

Accept *N900040100*

Setup **Start** *NS1* **Stop** *NS2*

Start Date: 22/12/2011 **Start Qty:** 1.00 *1*

Required Date: 01/02/2012 **Req'd Qty:** 1.00 *1*

Reference:

Cust Item ID:

Customer:

Run **Start** *NR1* **Stop** *NR2*

Approvals: **Process Plan:** ____________ **Date:** ________ **Tooling:** ________ **Date:** ________

QC: ________________ **Date:** ________ **SPC (Y/N):** ________ **Date:** ________

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200 *200* Skidtubes	Skidtubes	0.00 / 0.00				____	____	____	____

Skidtubes

Memo

1-remove alodine from around hole and prepare for welding

2-Prep per QSI 005 and Insert D2649 crossbolt spacers. Weld as per QSI 004 and Dwg D3804. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.
Pick:
QtyPart NumberDescriptionBatch
A/RAluminum Rod m119785 } BE 12-01-12

3-Grind welds flush as per Dwg D3804. JB 12/01/12

4-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D3804. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required.
A/RSS Rod NONE BE 12-01-12

5-Counterbore 5/16" x 0.750" deep except 7th hole from Aft end as per Dwg D3804. Deburr DP 12-1-12

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W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ______________________ **PAR #:** _______ **Fault Category:** ___________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

Resolution: _____________________ **Disposition:** ______________________ **QA: N/C Closed:** __________ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID 77974
December-23-11 10:34:25 AM

77974

Item ID: D206-642-151
Revision ID:
Item Name: Replacement Skidtube

Accept *N900040100*

Setup **Start** *NS1*
Stop *NS2*

Start Date: 22/12/2011 **Start Qty:** 1.00 *1*
Required Date: 01/02/2012 **Req'd Qty:** 1.00 *1*
Reference:

Cust Item ID:
Customer:

Run **Start** *NR1*
Stop *NR2*

Approvals: **Process Plan:** ____________ **Date:** ________ **Tooling:** ________ **Date:** ________
QC: ____________ **Date:** ________ **SPC (Y/N):** ________ **Date:** ________

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210 *210* HandFinish Hand Finishing	HandFinishing **Memo** Install D2680-041 Nut Plate as per Dwg D3804	0.00 0.00			(1)	B	12/01/12		
215 *215* QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds **Memo**	0.00 0.00	[signature] 12.01.13						
220 *220* QC Quality Control	QC10- Inspect visual per QSI004- ground welds **Memo**	0.00 0.00	S 12/01/15						

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ PAR #: ______ Fault Category: ____________ NCR: Yes No DQA: _____ Date: ________

Resolution: ____________ Disposition: ____________ QA: N/C Closed: ________ Date: ________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 77974
December-23-11 10:34:25 AM

77974

Item ID: D206-642-151
Revision ID:
Item Name: Replacement Skidtube

Accept *N900040100*

Setup **Start** *NS1*
Stop *NS2*

Start Date: 22/12/2011 **Start Qty:** 1.00 *1*
Required Date: 01/02/2012 **Req'd Qty:** 1.00 *1*
Reference:

Cust Item ID:
Customer:

Run **Start** *NR1*
Stop *NR2*

Approvals: **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______
QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230 *230* QC Quality Control	QC5- Inspect part completeness to step on W/O **Memo**	0.00 0.00 S 17/01/15							
240 *240* HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 **Memo**	0.00 0.00				1X	∅	M-L	12/01/16
250 *250* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum **Memo** START TIME: 10:50 OVEN TEMPERATURE: 320 °F FINISH TIME: 11:20	0.00 0.00				1X	∅	M-L	12/01/16

m119480

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ________ **PAR #:** ________ **Fault Category:** ________ **NCR:** Yes No **DQA:** ________ **Date:** ________

Resolution: ________ **Disposition:** ________ **QA: N/C Closed:** ________ **Date:** ________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

Work Order ID 77974

December-23-11 10:34:25 AM

77974

Item ID: D206-642-151
Revision ID:
Item Name: Replacement Skidtube

Accept *N900040100*

Setup **Start** *NS1*
Stop *NS2*

Start Date: 22/12/2011 **Start Qty:** 1.00 *1*
Required Date: 01/02/2012 **Req'd Qty:** 1.00 *1*
Reference:

Cust Item ID:
Customer:

Run **Start** *NR1*
Stop *NR2*

Approvals: **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______
QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
260 *260* QC Quality Control	QC3- Inspect Part Finish **Memo**	0.00 0.00				1 LH	∅	JL	12/01/12
270 *270* LH HandFinish Hand Finishing	HandFinishing **Memo** 1-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install plugs as per Dwg D3804. Clean excess adhesive.	0.00 0.00				1 LH	∅	JL	12/01/12

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DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** ________

Resolution: ____________ **Disposition:** ____________ **QA: N/C Closed:** ________ **Date:** ________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
			Corrective Action Section B					
DATE	**STEP**	**Description of NC** Section A	**Initial** Chief Eng	**Action Description** Chief Eng	**Sign & Date**	**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector

NOTE: Date & initial all entries

Work Order ID 77974

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Item ID: D206-642-151 **Accept** *N900040100* **Setup** **Start** *NS1*

Revision ID:

Item Name: Replacement Skidtube **Stop** *NS2*

Start Date: 22/12/2011 **Start Qty:** 1.00 *1* **Cust Item ID:**

Required Date: 01/02/2012 **Req'd Qty:** 1.00 *1* **Customer:**

Reference:

Run **Start** *NR1*

Stop *NR2*

Approvals: **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280 *280* HandFinish Hand Finishing	HandFinishing	0.00				1	Ø	JM	12/01/12
	Memo	0.00							

1-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive
✓ A/RSikaflex-291 M119508
Sikaflex expire date: 12/09

✓ 2- Install wearplate as per dwg

2-Wing Walk as per Dwg D3804 and QSI 005 4.4
— Batch: M120125

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
290 *290* QC Quality Control	QC3- Inspect Part Finish	0.00	S 12/01/12						
	Memo	0.00							

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** ________

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Revision ID:
Item Name: Replacement Skidtube

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Setup **Start** *NS1*
Stop *NS2*

Start Date: 22/12/2011 **Start Qty:** 1.00 *1*
Required Date: 01/02/2012 **Req'd Qty:** 1.00 *1*
Reference:

Cust Item ID:
Customer:

Approvals: **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______
QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Run **Start** *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
300 *300* QC Quality Control	QC5- Inspect part completeness to step on W/O	0.00							
	Memo	0.00 S 12/01/18							
310 *310* Packaging Packaging	Packaging	0.00							
	Memo Identify and pack for shipping as per PPP D206-642-151 Location: PPP Rev: PPP 74379	0.00							C 12/01/18
320 *320* QC Quality Control	QC21- Final Inspection - Work Order Release	0.00							
	Memo	0.00							12/1/20

RL 12-01-20

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
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Part No: ________ **PAR #:** ________ **Fault Category:** ________ **NCR:** Yes No **DQA:** ______ **Date:** ________

Resolution: ________ **Disposition:** ________ **QA: N/C Closed:** ________ **Date:** ________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December-23-11 10:34:30 AM

8

Work Order ID: 77974 *77974*

Parent Item: D206-642-151 *D206-642-151*

Parent Item Name: Replacement Skidtube

Start Date: 22/12/2011 **Required Date:** 01/02/2012

Start Qty: 1.00 **Required Qty:** 1.00

Comments: IPP REV:A 10.12.08 PER IIN REV.N DD VERF:EC IPP REV:B 11.09.16 PER IIN REV.O DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2620 *D2620* Skidtube, 206 Skidtube		Manufactured	No			110	Each	13.0000	1	1 **	SAD	12-01-10	
D2647 *D2647* Cap		Manufactured	No			110	Each	183.0000	1	**		BE 12-01-10	

D2620 locations:

Location	Loc Qty	Loc Code	
LG	13		
71616	3		
71617	6		
75470	2		
75587	2	B 76815	1

D2647 locations:

Location	Loc Qty	Loc Code	
LG002	183		
73826	74		1
75482	109		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ______________ PAR #: _______ Fault Category: ______________ NCR: Yes No DQA: _____ Date: _________

Resolution: ______________ Disposition: ______________ QA: N/C Closed: _________ Date: _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Work Order ID: 77974

77974

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 22/12/2011 **Required Date:** 01/02/2012

Start Qty: 1.00 **Required Qty:** 1.00

CR3212-4-04 Purchased No 180 Each 12,557.00 52 52

CR3212-4-04 ** DL 12/01/11

Cherry Rivet

Location		Loc Qty	Loc Code	
ST331		2567		
	116471	78		
	117816	3		
	118686	1		
	118840	16		
	119017	2459		
	119075	10		52
st510		9990		
	119075	9990		

D2654-1 Manufactured No 180 Each 0.0000 1 1

D2654-1 76757 ** 1 BB 12/01/11

Web

D3286-1 Manufactured No 180 Each 178.0000 2 2

D3286-1 ** SAD 12-01-10

Doubler

Location		Loc Qty	Loc Code	
LG002		178		
	74872	6		
	75484	54		2

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ PAR #: _______ Fault Category: __________________ NCR: Yes No DQA: _____ Date: _________

Resolution: ____________________ Disposition: ____________________ QA: N/C Closed: __________ Date: _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID: 77974 *77974*

Parent Item: D206-642-151 *D206-642-151*

Parent Item Name: Replacement Skidtube

Start Date: 22/12/2011 **Required Date:** 01/02/2012

Start Qty: 1.00 **Required Qty:** 1.00

D2649 Manufactured No 200 Each 634.0000 19 19

D2649

Cross Bolt Spacer ** BE12-01-12

Location		Loc Qty	Loc Code
LG001		634	
	65317	1	
	68224	2	
	68507	11	
	71355	2	
	72704	2	
	72841	11	
	73390	8	
	73857	21	
	73858	53	
	73859	4	
	73860	4	
	76793	515	19

D3286-3 Manufactured No 200 Each 18.0000 2 2

D3286-3

Spacer ** BE12-01-12 B 76773 ×2

Location		Loc Qty	Loc Code
LG001		1	
	74117	1	
LG002		17	
	75483	17	

D2680-041 Manufactured No 210 Each 64.0000 1 1

D2680-041

Nut Plate ** (1) B 12/01/12

Location		Loc Qty	Loc Code
ST020		64	
	75479	64	

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ PAR #: _______ Fault Category: __________________ NCR: Yes No DQA: _____ Date: _________

Resolution: ____________________ Disposition: ____________________ QA: N/C Closed: __________ Date: _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

. Picklist Print

December-23-11 10:34:30 AM

Work Order ID: 77974 *77974*

Parent Item: D206-642-151 *D206-642-151*

Parent Item Name: Replacement Skidtube

Start Date: 22/12/2011 **Required Date:** 01/02/2012

Start Qty: 1.00 **Required Qty:** 1.00

Item		Type							
CR3212-4-03 *CR3212-4-03* Cherry Rivet		Purchased	No	210	Each	1,762.000	2	**	2 ② 12/01/12
AN960JD416 *AN960JD416* Washer	NAS1149D0463J	Purchased	No	210	Each	0.0000	1	**	1 M118384 (x1) 12/01/17
CCR264SS3-3 *CCR264SS3-3* Cherry Rivet		Purchased	No	210	Each	993.0000	2	**	2 ② 12/01/12
MS27039-4-06 *MS27039-4-06* Screw		Purchased	No	210	Each	323.0000	1	**	1 12/01/17

CR3212-4-03:

Location		Loc Qty	Loc Code
FP002		768	
	114859	768	
ST331		994	
	110139	2	
	119017	992	

CCR264SS3-3:

Location		Loc Qty	Loc Code
ST331		993	
	113973	2	
	117849	147	
	119017	844	

MS27039-4-06:

Location		Loc Qty	Loc Code
ST292		323	
	119075	323	✓

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ PAR #: ______ Fault Category: ____________ NCR: Yes No DQA: _____ Date: ________

Resolution: ____________ Disposition: ____________ QA: N/C Closed: ________ Date: ________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December-23-11 10:34:30 AM

Work Order ID: 77974 *77974*

Parent Item: D206-642-151 *D206-642-151*

Parent Item Name: Replacement Skidtube

Start Date: 22/12/2011 **Required Date:** 01/02/2012

Start Qty: 1.00 **Required Qty:** 1.00

D2651-1 Manufactured No 270 Each 357.0000 6 6

D2651-1 ** JU 12/01/17

Plug

Location		Loc Qty	Loc Code	
FP001		357		
	57869	1		
	66445	10		
	69018	2		
	70839	2		
	71037	31		
	73827	311		X6

D2651-3 Manufactured No 270 Each 847.0000 6 6

D2651-3 ** JU 12/01/17

O-Ring

Location		Loc Qty	Loc Code	
FP001		847		
	61962	12		
	73828	835		X6

D3873-1 Manufactured No 280 Each 611.0000 14 14

D3873-1 ** JU 12/01/17

Bushing

Location		Loc Qty	Loc Code	
ST088		611		
	64760	1		
	68247	4		
	73829	19		
	73830	2		
	76792	585		X14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** ________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

Resolution: ____________________ **Disposition:** ____________________ **QA: N/C Closed:** _________ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

Work Order ID: 77974

77974

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 22/12/2011 **Required Date:** 01/02/2012
Start Qty: 1.00 **Required Qty:** 1.00

D2646 | Manufactured | No | 280 | Each | 153.0000 | 1 | 1

D2646
Aft Cap

** M 12/01/17

Location		Loc Qty	Loc Code	
FP002		153		
	62678	5		
	68280	5		
	70945	1		
	71038	4		
	71070	2		
	73294	1		
	73825	135		X1

D3805-041 | Manufactured | No | 280 | Each | 1.0000 | 1 | 1

D3805-041
Wearplate Assembly Fwd, Low Gear

** 1376775 (x1) M 12/01/17

Location		Loc Qty	Loc Code
FP001		1	
	75149	1	

MS27039-1-08 | Purchased | No | 280 | Each | 1,243.000 | 2 | 2

MS27039-1-08
Screw

** M 12/01/17

Location		Loc Qty	Loc Code	
ST291		1243		
	117423	77		
	118910	226		X2
	119075	440		
	119109	500		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ PAR #: ______ Fault Category: ____________ NCR: Yes No DQA: _____ Date: ______

Resolution: ____________ Disposition: ____________ QA: N/C Closed: ________ Date: ______

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID: 77974 *77974*

Parent Item: D206-642-151 *D206-642-151*

Parent Item Name: Replacement Skidtube

Start Date: 22/12/2011 **Required Date:** 01/02/2012

Start Qty: 1.00 **Required Qty:** 1.00

MS21042L3 | Purchased | No | 280 | Each | 6,837.000 | 7 | 7

MS21042L3 ** JU 12/01/17

Nut

Location	Loc Qty	Loc Code	
ST300	6837		
117441	16		
117885	32		
118451	5		
118927	3		
119017	5988		X 7
119075	793		

D3805-045 | Manufactured | No | 280 | Each | 2.0000 | 1 | 1

D3805-045 ** B76785(x1) JU 12/01/17

Wearplate Assembly Aft, Low Gear

Location	Loc Qty	Loc Code
FP001	2	
73817	1	
74896	1	

AN960JD10L NAS1149D0332J | Purchased | No | 280 | Each | 0.0000 | 2 | 2

AN960JD10L X ** M119042 (x2) JU 12/01/17

Washer

AN3-37A | Purchased | No | 280 | Each | 1,546.000 | 7 | 7

AN3-37A ** JU 12/01/17

Bolt

Location	Loc Qty	Loc Code	
ST353	1546		
117619	4		
119086	1542		X7

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ PAR #: _______ Fault Category: __________________ NCR: Yes No DQA: _____ Date: _________

Resolution: ___________________ Disposition: ____________________ QA: N/C Closed: __________ Date: _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID: 77974 *77974*

Parent Item: D206-642-151 *D206-642-151*

Parent Item Name: Replacement Skidtube

Start Date: 22/12/2011 **Required Date:** 01/02/2012

Start Qty: 1.00 **Required Qty:** 1.00

NAS1149D0363J Purchased No 280 Each 2,252.000 7 7

NAS1149D0363J ** ML 11/01/17

Washer

Location	Loc Qty	Loc Code	
ST298	2252		
117601	61		
118077	1		
118612	18		
118968	137		
119537	2035		X7

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** ________

Resolution: ____________ **Disposition:** ____________ **QA: N/C Closed:** ________ **Date:** ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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ITEM	Qty -041	Qty -043	Part Number	Description
1	X		D3804-041	SKIDTUBE ASSEMBLY, 206 A/B LOW
2		X	D3804-043	SKIDTUBE ASSEMBLY, 206 A/B HIGH
5	1	1	D2600-1-160	EXTRUSION
6	1	1	D2646	AFT CAP
7	1	1	D2647	CAP
8	19	20	D2649	CROSS BOLT SPACER
9	6	8	D2651-1	PLUG
10	6	8	D2651-3	O-RING
11		1	D2654-3	WEB
12	1		D2654-1	WEB
13	1	1	D2680-041	NUT PLATE
14	2	2	D3286-1	DOUBLER
15	2	2	D3286-3	STUD
21	2	2	AN960JD10L	WASHER
22	1	1	AN960JD416	WASHER
23	2	2	CCR264SS3-3	RIVET
24	2	2	CR3212-4-03	RIVET
25	52	52	CR3212-4-04	RIVET
26	2	2	MS27039-1-08	SCREW
27	1	1	MS27039-4-06	SCREW

NOTES

1) MATERIAL: N/A
2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
   -POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
3) BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
7) IDENTIFICATION: NONE
8) WEIGHT: 12.5 lb
9) WELD PER DART QSI 004
10) BENDING: DAMAGE TOLERANCE ON FWD BEND:
    THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
11) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
12) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	MB	08.07.07

DESIGN		DART AEROSPACE USA, INC PORT HADLOCK, WA
DRAWN		
CHECKED		DRAWING NO. D3804 — REV. A — SHEET 1 OF 5
MFG. APPR.		
APPROVED		TITLE: SKIDTUBE ASSEMBLY, 206A/B — SCALE: NTS
DE APPR.		
DATE	08.07.07	

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** ________

Resolution: ____________ **Disposition:** ____________ **QA: N/C Closed:** ________ **Date:** ________

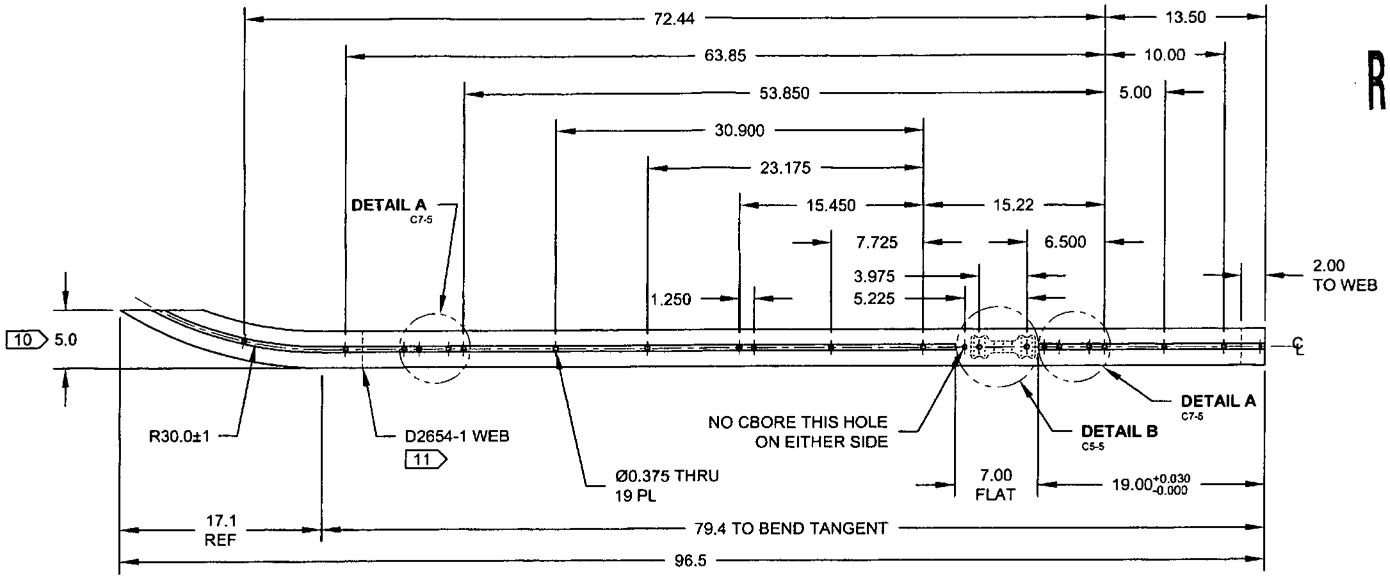
NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

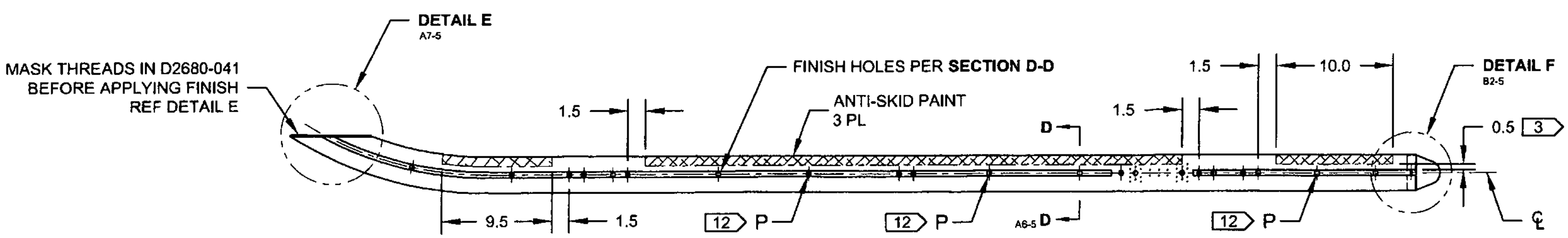
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77974

RELEASED 09.03.07



D3804-041 BENDING/DRILLING DETAIL



D3804-041 ASSEMBLY/FINISHING DETAIL

DESIGN		DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN			
CHECKED		DRAWING NO. D3804	REV. A SHEET 2 OF 5
MFG. APPR.			
APPROVED		TITLE SKIDTUBE ASSEMBLY, 206A/B	SCALE NTS
DE APPR.			
DATE	08.07.07		

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** ________

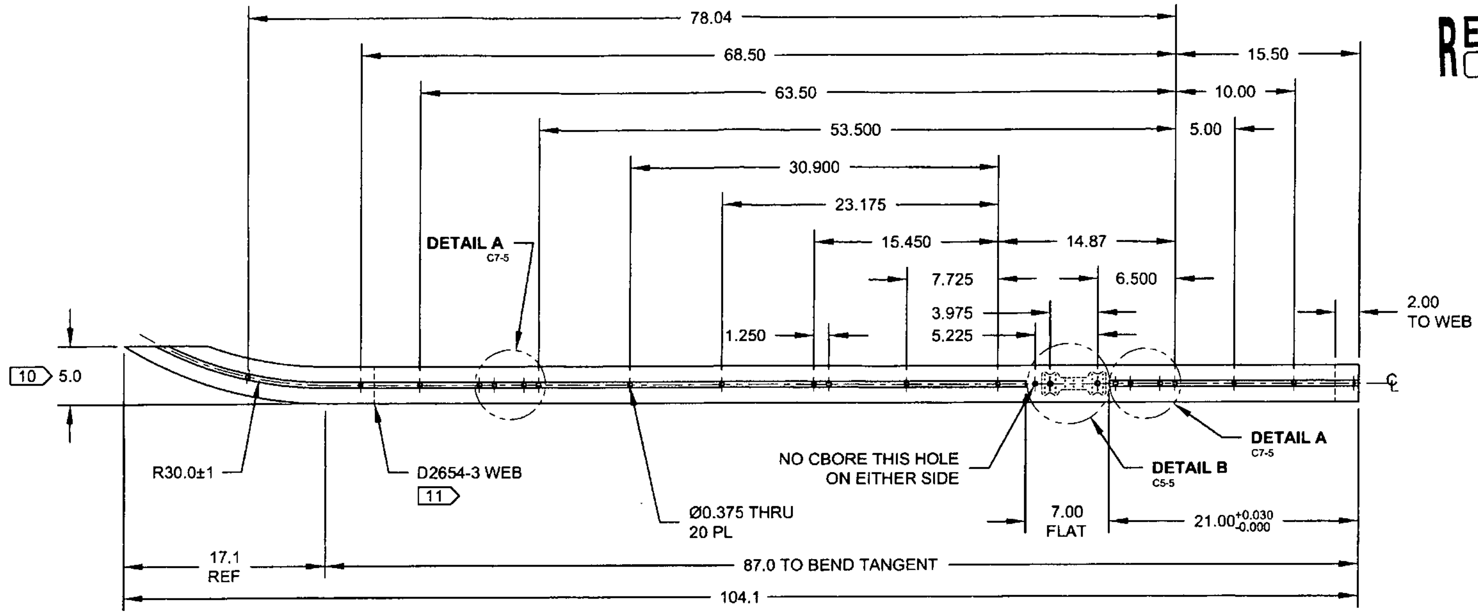
Resolution: ____________ **Disposition:** ____________ **QA: N/C Closed:** ________ **Date:** ________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

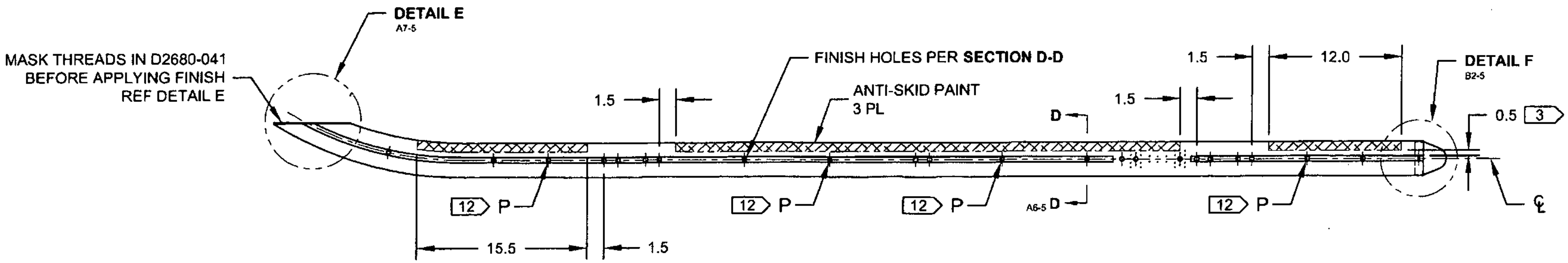
NOTE: Date & initial all entries

77974

RELEASED



D3804-043 BENDING/DRILLING DETAIL



D3804-043 ASSEMBLY/FINISHING DETAIL

		DART AEROSPACE USA, INC PORT HADLOCK, WA	
DESIGN	[signature]		
DRAWN	[signature]		
CHECKED	[signature]	DRAWING NO.	REV. A
MFG. APPR.	[signature]	D3804	SHEET 3 OF 5
APPROVED	[signature]	TITLE	SCALE
DE APPR.	[signature]	SKIDTUBE ASSEMBLY, 206A/B	NTS
DATE	08.07.07		

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

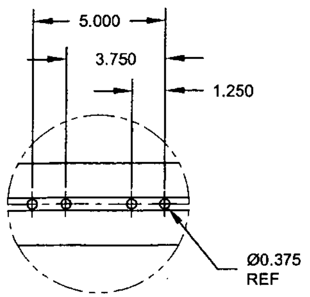
Part No: ________________ PAR #: _______ Fault Category: ________________ NCR: Yes No DQA: _____ Date: _________

Resolution: ________________ Disposition: ________________ QA: N/C Closed: _________ Date: _________

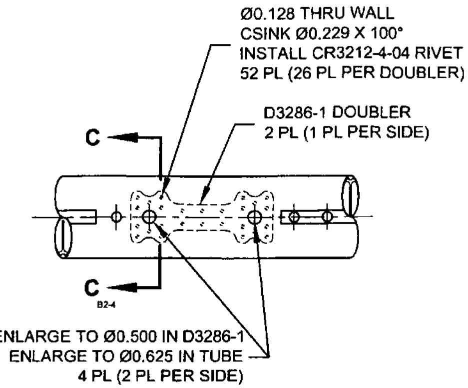
NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

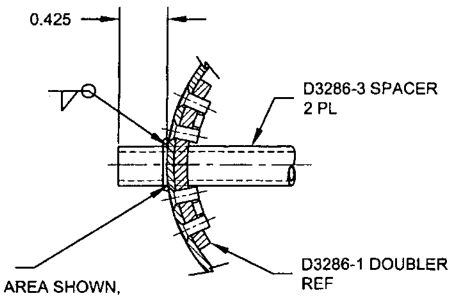
RELEASED 09.03.07



DETAIL A D6-2 C2-2 D6-3 C2-3
SCALE NONE

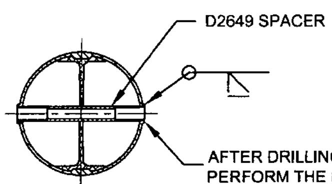


DETAIL B C3-2 C3-3
SCALE NONE



TO INSTALL D3286-1/-3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH OUTSIDE SURFACE OF ROUND TUBE
2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
3. ENLARGE HOLES IN D3286-1 TO Ø0.500
4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.03 X 45°
5. RIVET D3286-1 TO TUBE
6. INSERT D3286-3 SPACER
7. WELD IN PLACE AND GRIND FLUSH

SECTION C-C C6-4
PARTIAL SECTION
SCALE NONE



AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.03 X 45°
2. INSERT D2649 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. CBORE TO Ø0.313 X 0.75 DP (EXCEPT WHERE INDICATED)

SECTION D-D A4-2 A4-3
FOR Ø0.375 HOLES ONLY
SCALE NONE

DESIGN	GP	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	[illegible]	DRAWING NO.	REV. A
CHECKED	GP	D3804	SHEET 4 OF 5
MFG. APPR.	[illegible]	TITLE	SCALE
APPROVED	[illegible]	SKIDTUBE ASSEMBLY, 206A/B	NTS
DE APPR.	[illegible]		
DATE	08.07.07		

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** ________

Resolution: ____________ **Disposition:** ____________ **QA: N/C Closed:** ________ **Date:** ________

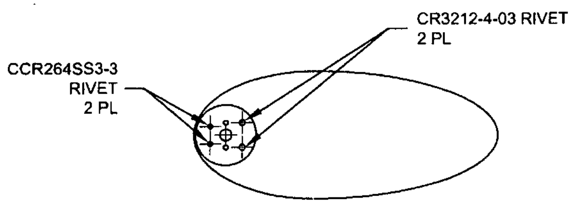
NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
			Corrective Action Section B					
DATE	**STEP**	**Description of NC** Section A	**Initial** Chief Eng	**Action Description** Chief Eng	**Sign & Date**	**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector

NOTE: Date & initial all entries

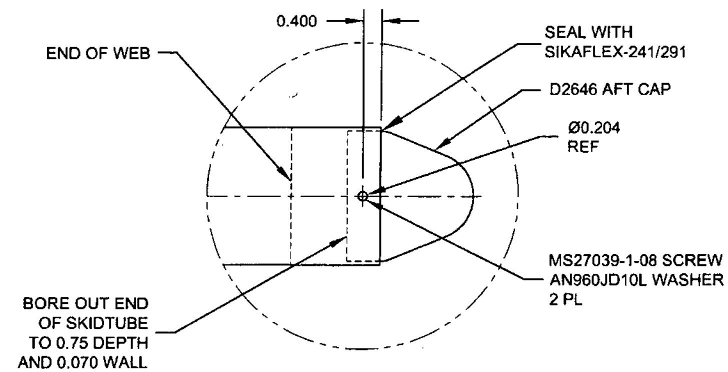
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77974

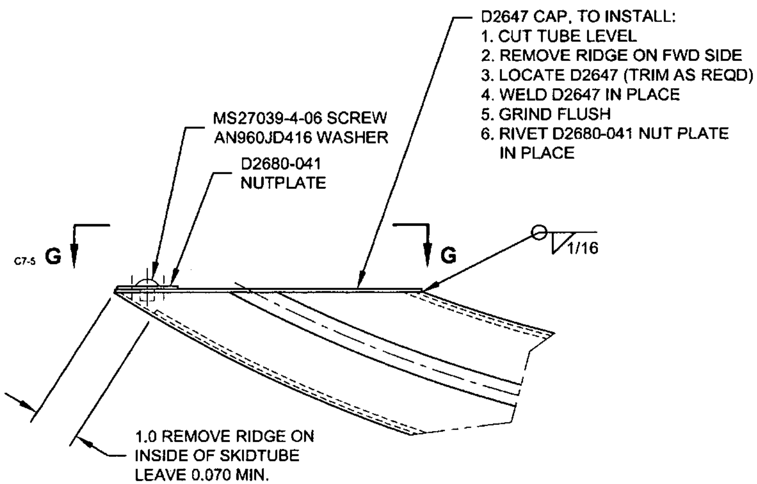
RELEASED [initials] 09.03.07



VIEW G-G
SCALE NONE A7-5



DETAIL F
SCALE NONE B2-2 B2-3



DETAIL E
SCALE NONE B7-2 B7-3

DESIGN	[initials]	DART AEROSPACE USA, INC PORT HADLOCK, WA
DRAWN	[initials]	
CHECKED	[initials]	DRAWING NO. D3804 — REV. A — SHEET 5 OF 5
MFG. APPR.	[initials]	
APPROVED	[initials]	TITLE: SKIDTUBE ASSEMBLY, 206A/B — SCALE: NTS
DE APPR.	[initials]	
DATE	08.07.07	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ PAR #: ______ Fault Category: ____________ NCR: Yes No DQA: ______ Date: ______

Resolution: ____________ Disposition: ____________ QA: N/C Closed: ______ Date: ______

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

NO. 278

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliot
Job number: 76619
Part number: 206-642-151
Description: 206 skidtube
Welding Process: Tig[X] Mig[ ]
Base materiel: Aluminum
Current: AC[X] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual:	pass[X] fail[ ]
Penetration:	pass[X] fail[ ]

UNACCEPTABLE

Cracks:	pass[X] fail[ ]
Undercut:	pass[X] fail[ ]
Pin holes:	pass[X] fail[ ]
Overlap (cold lap)	pass[X] fail[ ]
Porosity (surface):	pass[X] fail[ ]
Coloration:	pass[X] fail[ ]

Qualifier [signature] **Date of Test Coupon** 11·12·20

Welder Barclay Elliott **Date of Test Coupon** 11·12·20

The above named individual is qualified in accordance with AWS D17.1.2001 to weld